Work Order ID 62373

September 28, 2010 1:54:01 PM

Item ID: D4037-3 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Fwd Crossbeam

Start Date: 28/09/2010 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 04/10/2010 **Req'd Qty:** 2.00 **Customer:**

Reference: Tom 10-09-28

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D4037	C								
100		0.00							
Waterjet	**Memo**	0.00				B10-9-28			
FLOW CNC Waterjet	Cut blank as per file D4037-3_BLANK					(2)			
110		0.00							
HAAS 1	**Memo**	0.00				2	Ø		
HAAS CNC vertical machine #1	MACHINE AS PER FOLI FA878 AND DWG FOLIO REV: AA DWG REV: C DEBURR	ark 10/09/30							

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Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00	ok 10/09/30			2	0		
Quality Control									
130		0.00	M.A 10/10/01						
QC ok 10.09.30	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00	10/10/01			X2	0		
Hand Finishing									

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Start Date: 28/09/2010 **Start Qty:** 2.00 **Cust Item ID:**

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Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop**

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00 BR 10-10-4							
Powdercoat	M165291 START: 7:40								
Powder Coating	Memo OVEN T: 320° FINISH: 8:10	0.00				(2)			
160	QC3- Inspect Part Finish	0.00							
QC									
Quality Control	Memo	0.00 =JW 10/10/01				X2	Ø		
170	Identify as per dwg & Stock Location 201	0.00							
Packaging									
Packaging	Memo	0.00				10/10/01 SF	2		

Work Order ID 62373

September 28, 2010 1:54:01 PM

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Start Date: 28/09/2010 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 04/10/2010 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** _____ **Date:**_____ **Tooling:** _____ **Date:**_____ **Run Start** **Stop**

QC: _____ **Date:**_____ **SPC (Y/N):** _____ **Date:**_____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
QC	**Memo**	0.00				____	10/10/04		
Quality Control									

10/10/04

Picklist Print

September 28, 2010 1:54:01 PM

Work Order ID: 62373

Parent Item: D4037-3

Parent Item Name: Fwd Crossbeam

Start Date: 28/09/2010 **Required Date:** 04/10/2010

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP REV:A NEW ISSUE 09-12-14 JLM VERIFIED BY:EC IPP
REV:B AS PER REV B 10-04-19 JLM VERIFIED BY:EC IPP REV
C:AS PER ECN 10-563 10-09-28 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X15.000		Purchased	No			100	f	46.3000	3.9	8.210526			

6061-T6 Bar 1.00 x 15.00

IB 10-9-28

Location	Loc Qty	Loc Code
MAT	39.8	
114562	3.8	
114899	12	
115093	12	
115173	12	
MAT07	6.5	
9544	6.5	

114562 x 13.9 (L)

9544 x 13.9

DART AEROSPACE LTD	Work Order:	62373
Description: Fwd Crossbeam	Part Number:	D4037-3
Inspection Dwg: D4037 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
41.66	±.030	41.660	—		H-tape	ML-2
.92	±.030	.918	—		Vern	ML-7
1.75	±.030	1.748	—		"	"
.92	±.030	.919	—		"	"
2.125	± .010	2.122	—		"	"
Ø.316	±.006 .001	Ø.316	—		Vern	ML-7
Ø.391	±.006 .001	Ø.393	—		"	"
.28	±.030	.282	—		"	"
1.32	±.030	1.340	—		"	"
7.79	±.030	7.787	—		H-gage	31006
5.80	±.030	5.800	—		Vern	ML-7
2.250	±.010	2.251	—		"	"
.875	±.010	.870	—		"	"
6.000	±.010	5.996	—		"	"
7.75	±.030	7.750	—		H-tape	ML-2
[redacted]	[redacted]					
1.125	±.010	1.121	—		Vern	ML-7
9.29	±.030	9.290	—		H-tape	ML-2
1.75	±.030	1.749	—		Vern	ML-7
1.38	±.030	1.372	—		"	"
1.50	±.030	1.502	—		"	"
.63	±.030	.628	—		"	"
1.00	±.030	1.023	—		"	"

Measured by:		Audited by:	KJA	Prototype Approval:	N/A
Date:	10/09/30	Date:	10/10/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	62373
Description: Fwd Crossbeam	Part Number:	D4037-3
Inspection Dwg: D4037 Rev: C		Page 1 of 1

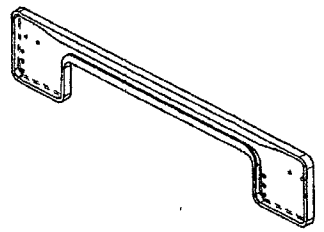
FIRST ARTICLE INSPECTION CHECKLIST

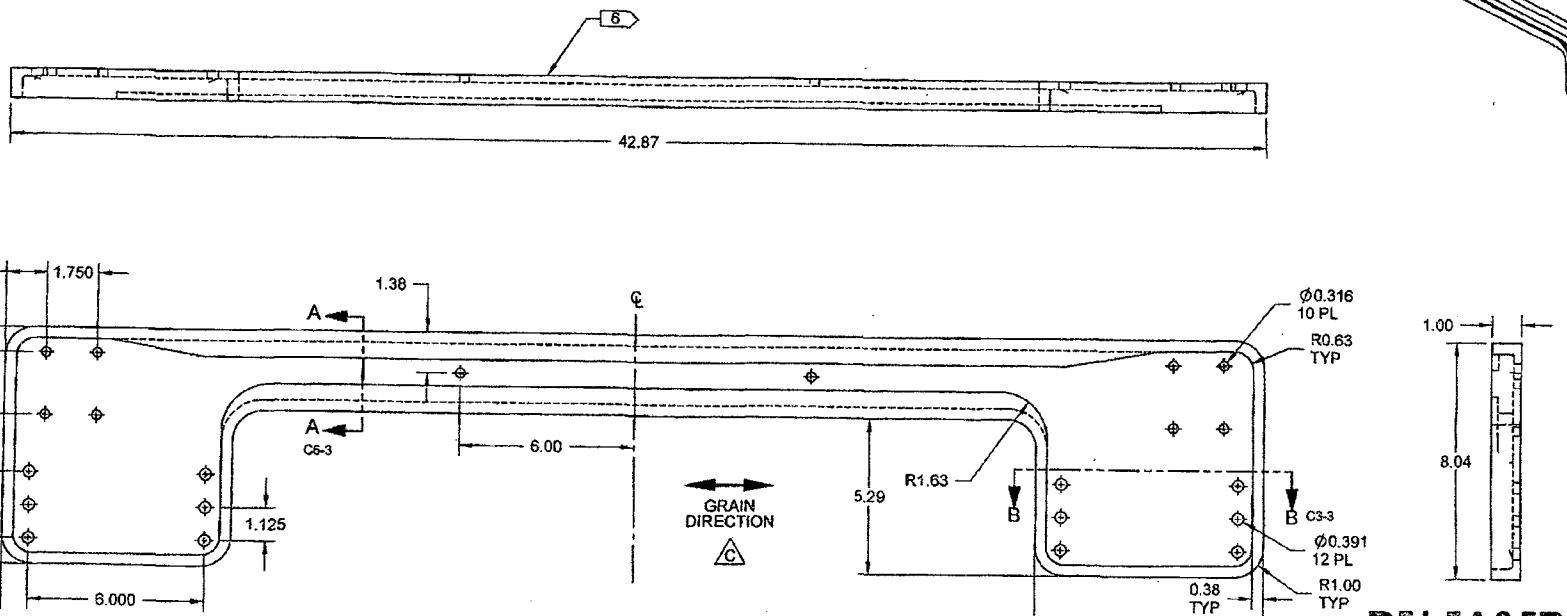
[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.79	±.030	10.791	—		H-gage	31006
3.00	±.030	3.004	—		Vern	ML-7
2.00	±.030	2.003	—		Micr	ML-02
.25	±.030	.256	✓		Micr	118-120
.530	±.010	.521	—		Micr	ML-01
.35	±.030	.380	—		Vern	ML-7
.35	±.030	.380	—		"	"
R.13	±.030	R.109	✓		Rad-gage	REF

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	10/09/01	Date:	10/10/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





RELEASED
2010 -09- 27

D4037-1 AFT CROSSBEAM

w/o 62373

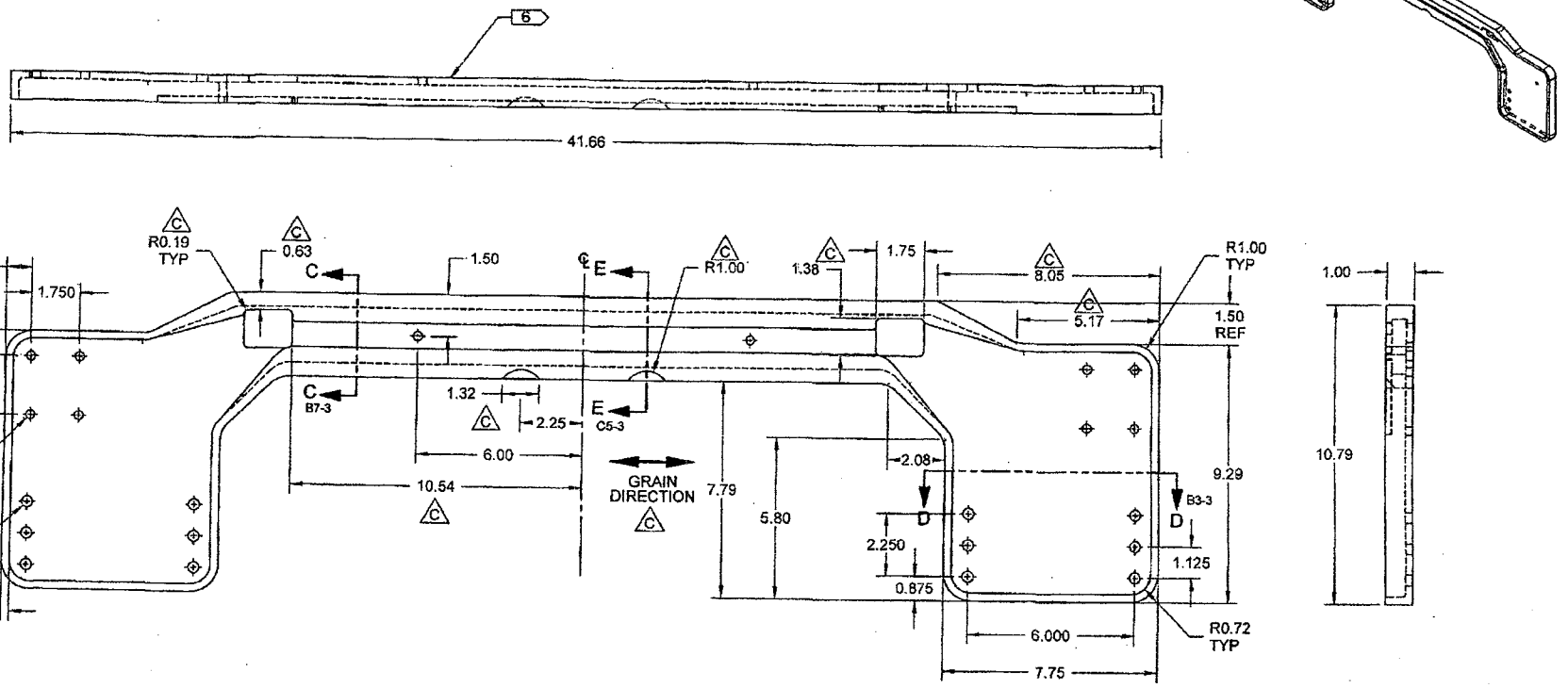
NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209 C
REF DART SPEC M6061T6S1.000
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 C
7) WEIGHT: 8.48 lbs
8) MACHINE PER DART SOLIDWORKS PART "D4037-1_REVC.SLDPRT" C

REV.	DESCRIPTION	BY	DATE
C	MODIFY -3 PART FOR CLEARANCE HOLES, SHT 2; UPDATE MATERIAL SPEC SHT 1, 2; 8.05 WAS 9.83; ADD GRAIN DIRECTION		10.09.15
B	ADJUST DIMS AND REPOSITION HOLES, ZN B4-1, C8-1, C8-2	HS	10.02.10
A	NEW ISSUE	HS	09.12.16

DESIGN	
DRAWN	
CHECKED	
MFG. APPR.	
APPROVED	
DE APPR.	
DATE	10.09.15

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4037 REV. C
SHEET 1 OF 3
TITLE CROSSBEAM
SCALE NTS



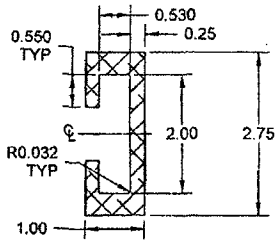
D4037-3 FWD CROSSBEAM

RELEASED
2010 -09- 27

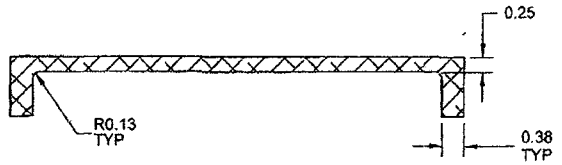
NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 1.000 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S1.000 C
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 C
7) WEIGHT: 9.12 lbs
8) MACHINE PER DART SOLIDWORKS PART "D4037-3_REVC.SLDPRT" C

w/o 62373

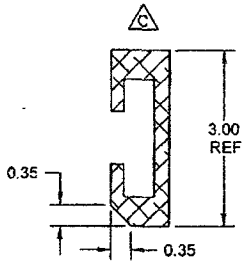
DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4037 REV. C
MFG. APPR.		SHEET 2 OF 3
APPROVED		TITLE CROSSBEAM SCALE NTS
DE APPR.		
DATE 10.09.15		



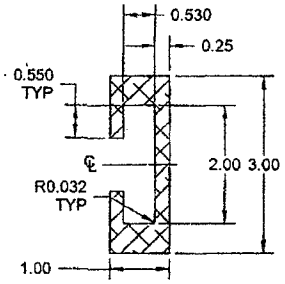
SECTION A-A B6-1
SCALE 2X



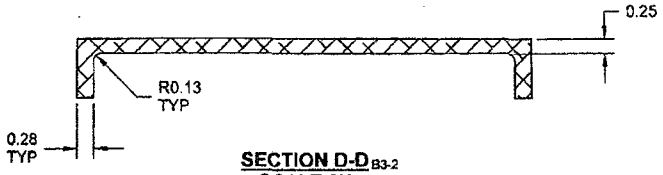
SECTION B-B B2-1
SCALE 2X



SECTION E-E C5-2
SCALE 2X



SECTION C-C B6-2
SCALE 2X



SECTION D-D B3-2
SCALE 2X

RELEASED
2010 -09- 23

w/o 62373.

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4037	REV. C
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE CROSSBEAM	SCALE NTS
DE APPR.			
DATE 10.09.15			